

Date: Wednesday, 11/22/2006 1:39:31 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT
Job Number	: 29647A		
Estimate Number	: 10452		
P.O. Number	: N/A	Part Number	: D32781
This Issue	: 11/22/2006	S.O. No.	: N/A
Prsh Rev.	: NC	Drawing Number	: D3278 REV. B
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29236A	Drawing Revision	: B
Written By	:	Material	: N/A
Checked & Approved By	:	Due Date	: 11/29/2006
Comment	: Est.A 04.04.19 New issue KJ/JLM	Qty:	"Split" 50 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
	Comment: Qty.: 0.2454 f(s)/Unit Total : 12.2693 f(s) Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000)	on 07/01/08 57 - 07/01/08 Batch: ATC 005 (200g SCRAPED) 719295 55 - 07/01/08
2.0	SHEAR SACI	SHEAR
	Comment: SHEAR Cut blank: 2.00" x 1.00" x 2.550" long	07/01/08 56 - 07/01/08
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA405 and Dwg D3278 2- Deburr and Tumble Identify as D3278-1	1 JF - 07/01/09
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	1 JF - 07/01/09
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	En 07/01/09 420

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/05	2	Material was cut too long because it was identified wrong. S WAS missing on mat'l size	J 06/11/05	# Material is no good for these supports. use scrap material. replace with correct mat'l. use material for testing	S G 06/11/05	J 06/12/05	J 06/12/05	J 06/12/05

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-h/a.n

(20X)

07/01/04

7.0 POWDER COATING

POWDER COATING



M 102391



(20X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-h/y/l 07/01/10

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

mlo7/01/11

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: GA

mlo7/01/11

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

F 07/01/11

Job Completion



U 07.01.11

DART AEROSPACE LTD	Work Order:	29647A
Description: Support	Part Number:	D3278-1
Inspection Dwg: D3278	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.099	✓			
0.359	+/-0.005	.359	✓			
0.615	+/-0.010					
0.250	+/-0.010	.251	✓			
1.480	+/-0.005	1.480	✓			
R0.125	+/-0.010	.125	✓			
0.119	+0.005/-0.004	.124				
2.439	+/-0.010	2.440	✓			
1.980	+/-0.010	1.985	✓			
R0.130	+/-0.010	.130	✓			
Ø0.257	+0.005/-0.000	.260	✓			
R0.375	+/-0.010	.375	✓			
0.875	+/-0.010	.875	✓			
0.500	+/-0.010	.500	✓			
R0.400	+/-0.010	.400	✓			
1.720	+/-0.010	1.722	✓			
R0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.130	✓			

Measured by:	JL	Audited by:	✓	Prototype Approval:	N/A
Date:	07/01/08	Date:	07/01/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM ✓	✓

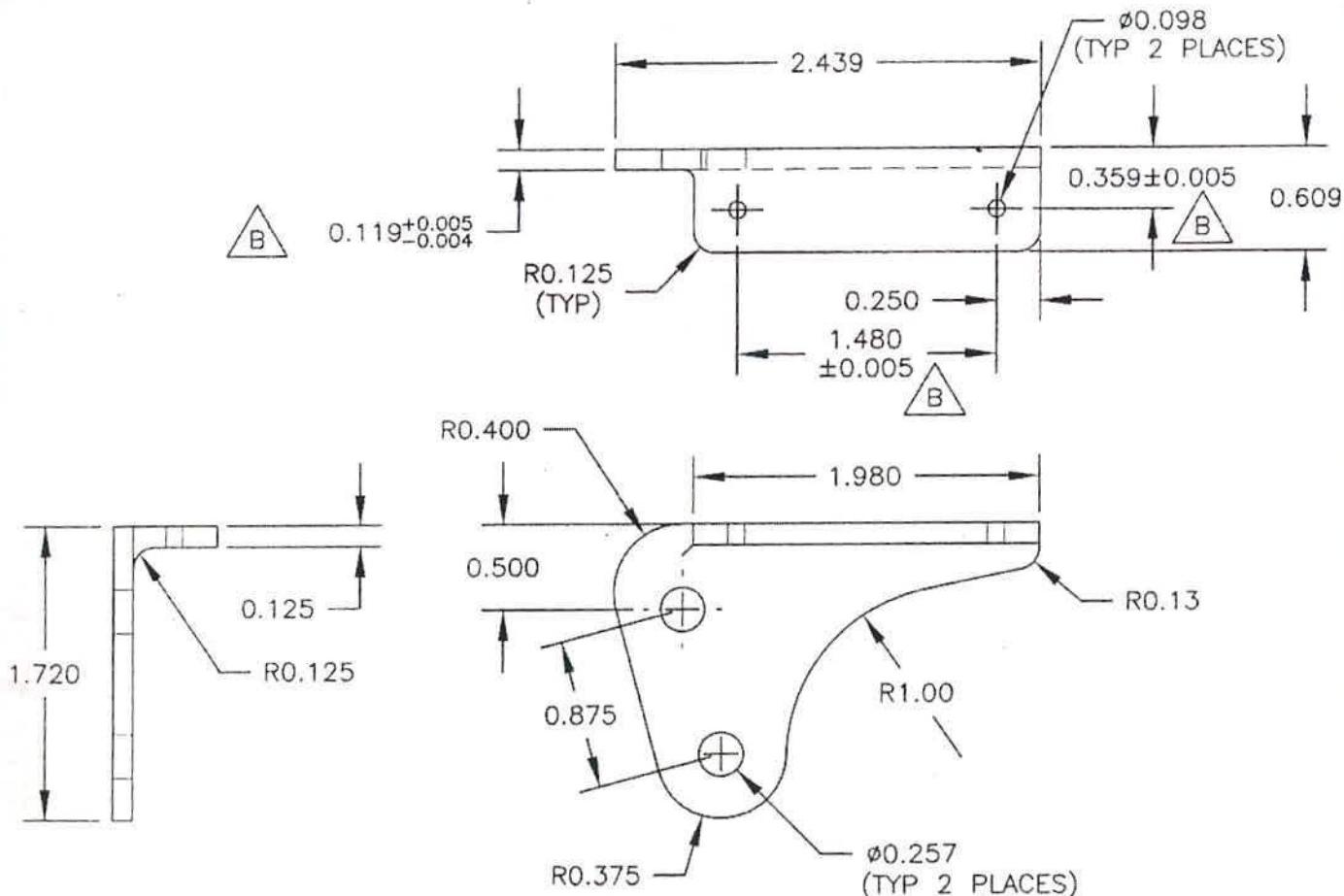
115

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278
DATE 05.03.31	TITLE SUPPORT ASSEMBLY	REV. B SHEET 2 OF 3 SCALE 1:1

RELEASED

05-04-04 *[Signature]*



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

INCONTR
AUTOMATED
WORKFLOW
29647A

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